

**\*89767\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

**Cust Item ID:**

**Customer:**

**Reference:**

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
DSI 9484	C

100

**\*100\***

DC

Document Control

## Memo

Photocopy bluefile & type labels per PPP D412-698-027/ DSI9484  
CHG003

0.00

0.00

110

## Pick Kit

0.00

**\*110\***

### Packaging

## Packaging

## Memo

0.00

120

QC4- 100% Inspect kits for completeness

0.00

**\*120\***

QC

## Quality Control

## Memo

0.00

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

  

FAULT CATEGORY			
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other

# Picklist Print

Wednesday, September 05, 2012 12:31:03

Page 1

Work Order ID: 89767

Parent Item: D412-698-027

Parent Item Name: Bracket Assembly, LH (Aluminum Doors)

Start Date: 9/12/2012

Required Date: 9/14/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC  
ECN11-531 verified by:EC

IPP Rev:B 11.03.31 AS PER

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D31993 Bracket, Fwd LH		Manufactured	No			110	Each	25.0000	1				

Location

Loc Qty

Loc Code

ST236B

25

75206

8

77361

17

2x

SP<sup>2</sup> 12-9-26.

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
<b>Root Cause</b>	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
<b>Landing Gear</b>			<b>General</b>						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other					
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-698 REV. E OR LATER APPROVED REVISION  
AND ICA-D412-698 REV. 5 OR LATER APPROVED REVISION

REF. TCCA STC: SH92-43  
REF. FAA STC: SR01446NY  
REF. EASA.IM.R.S.00709

**REFERENCE ONLY**

Field experience has shown that the forward D3199-1 brackets that are part of the D412-698-011/-012/-017 Cabin Door Roller Kits and forward D3675-1 brackets that are part of the D412-698-031/-032/-033 Cabin Door Roller Kits may wear prematurely if the aircraft is flown a significant amount of time with the sliding doors open. Dart has developed the D412-698-027/-028 kits that includes a longer D3199-3/-4 bracket for installation in the first forward position of the D412-698-011/-012/-017 kits to reduce wear on these forward brackets on aircraft equipped with aluminum doors. Likewise, Dart has developed the D412-698-037/-038 kits that includes a longer D3675-5/-6 bracket for installation in the first forward position of the D412-698-031/-032/-033 kits to reduce wear on these forward brackets on aircraft equipped with composite doors.

The D412-698-027/-028/-037/-038 kits may be installed as follows:

- 1) Remove the sliding door from the aircraft per Section 52.1 of ICA-D412-698
- 2) Remove the first forward D3199-1 or D3675-1 brackets as applicable.
- 3) Install the D3199-3/-4 or D3675-5/-6 bracket as applicable in lieu of the removed -1 bracket.  
Refer to Figure 1 Sheet 2 (aluminum doors) or Figure 2 Sheet 3 (composite doors).
- 4) Torque hardware per ICA-D412-698.
- 5) Re-install sliding door on aircraft per Section 52.2/52.3 of ICA-D412-698 as applicable.
- 6) Make entry in technical records of aircraft indicating that DSI 9484 has been completed.

## PARTS LIST

QTY. -027	QTY. -028	QTY. -037	QTY. -038	PART NUMBER	DESCRIPTION
X				D412-698-027	BRACKET KIT, LH (ALUMINUM DOORS)
	X			D412-698-028	BRACKET KIT, RH (ALUMINUM DOORS)
		X		D412-698-037	BRACKET KIT, LH (COMPOSITE DOORS)
			X	D412-698-038	BRACKET KIT, RH (COMPOSITE DOORS)
				D3199-3	FORWARD BRACKET, LH
				D3199-4	FORWARD BRACKET, RH
		1		D3675-5	FORWARD BRACKET, LH
			1	D3675-6	FORWARD BRACKET, RH

## WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal		Applicability
		Arm	Moment	Arm	Moment	
D412-698-027 Bracket Kit	0.16 lb 0.07 kg	-48.0 in -1.22 m	-7.68 in-lb -0.09 m-k	102.3 in 2.60 m	16.37 in-lb 0.18 m-k	Aircraft Equipped with P/N 205-032-669-XXX Aluminum Doors
D412-698-028 Bracket Kit	0.16 lbs 0.07 kg	+48.0 +1.22 m	+7.68 in-lb +0.09 m-k	102.3 in 2.60 m	16.37 in-lb 0.18 m-k	
D412-698-037 Bracket Kit	0.18 lb 0.08 kg	-48.0 in -1.22 m	-8.64 in-lb -0.10 m-k	102.3 in 2.60 m	18.41 in-lb 0.21 m-k	Aircraft Equipped with P/N 412-030-300-XXX Composite Doors
D412-698-038 Bracket Kit	0.18 lb 0.08 kg	+48.0 in +1.22 m	+8.64 in-lb +0.10 m-k	102.3 in 2.60 m	18.41 in-lb 0.21 m-k	

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 11.03.21  
CERT. NO.: SH92-43  
ISSUE NO.: 5

C	UPDATED -027/-028/-037/-038 KITS AND INSTALLATION	MB	11.03.21
B	ADDED -037/-038 KIT FOR COMPOSITE DOORS; UPDATED TITLE ACCORDINGLY.	MB	10.12.17
A	NEW ISSUE	<i>[Signature]</i>	09.10.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>[Signature]</i>		
CHECKED	ASS	DRAWING NO.	REV. C
MFG. APPR.	NA	DSI 9484	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	D412-698-027/-028/-037/-038 Kits	NTS
DATE	11.03.21	COPYRIGHT © 2009 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	